

Amendments to the Claims

The listing of claims below replaces all previous versions.

1. (Currently Amended) A method of attaching a pair of end caps to a core of a feed roll for mounting to the frame of a master processing apparatus in which a master processing operation is performed, said method comprising:

providing a tubular core with a supply of stock material wound about said core;

providing a pair of end caps each having a ~~tubular~~ core securing portion and a mounting portion connected to said core securing portion, said core securing portions normally being in a relaxed, unexpanded condition to enable insertion of said securing portions into opposing ends of said core, said mounting portions being configured to enable said feed ~~rolls~~ roll to be mounted on said frame in an operative position;

providing a pair of expansion members each being constructed and arranged to be ~~inserted into~~ moved inwardly relative to the core securing portion of a respective end cap;

inserting the core securing portions into the opposing ends of said core;

~~inserting an~~ moving each expansion member ~~into each said~~ inwardly relative to a respective core securing portion, ~~each said expansion member being configured~~ such that ~~said each~~ expansion member radially expands ~~said its respective~~ core securing portion ~~upon insertion therein~~ into a force fit relation with the interior surface of said core, thereby securing each said end cap to said core;

wherein said providing the pair of end caps and said providing the pair of expansion members includes providing the end caps and the expansion members such that each end cap and each expansion member is constructed of a molded plastic material and each expansion member is integrally connected to a respective end cap and held in substantial alignment with its respective core securing portion by a frangible connection so that each end cap and the associated expansion member are provided as a single molded plastic component,

said method further comprising breaking the frangible connection between each expansion member and the associated end cap to separate each expansion member from the associated end cap as each expansion member is being moved inwardly relative to each said core securing portion as aforesaid.

Please cancel claim 2.

2. (Cancelled)

3. (Currently Amended) A method according to claim [[2]] 1, wherein ~~each expansion member is connected by said frangible connection to a respective end cap in axial alignment with the tubular core securing portion such that said~~ breaking said frangible connection and ~~said inserting~~ moving an expansion member inwardly into a respective core securing portion are accomplished simultaneously by applying an axially directed force to said expansion member.

4. (Original) A method according to claim 3, wherein said tubular core is constructed of a paper or a cardboard material and wherein each tubular core securing portion is generally in the form of a cylindrical tube having a split free end, said split free end of each said core securing portion defining a plurality of tabs, each tab including gripping structure on the exterior thereof, said inserting an expansion member into each said core securing portion further comprising radially expanding said core securing portion such that said tabs flex outwardly and said gripping structures grip said paper or cardboard material.

Please cancel claims 5, 6 and 7.

5. (Cancelled)

6. (Cancelled)

7. (Cancelled)

8. (New) An end cap system for mounting to a feed roll having a tubular core with a supply of stock material wound about the core, the feed roll being for use with a master processing apparatus in which a master processing operation is performed, the end cap system comprising:

(i) an end cap comprising:

a core securing portion, the core securing portion being in a relaxed, unexpanded condition to enable insertion thereof into an end of the core;

a mounting portion connected to the core securing portion, the mounting portion being configured to enable the feed roll to be mounted to a frame of the apparatus in an operative position; and

(ii) an expansion member constructed and arranged to be moved inwardly relative to the core securing portion, the expansion member being configured such that, when the core securing portion is inserted into the end of the core, the expansion member radially expands the core securing portion into a force fit relation with the interior surface of the core upon the expansion member being moved inwardly relative to the core securing portion, thereby securing the end cap to the core,

wherein the end cap and the expansion member are constructed of a molded plastic material and the expansion member is integrally connected to the end cap and held in substantial alignment with the core securing portion by a frangible connection so that the end cap and expansion member are provided as a single molded plastic component, the frangible connection being breakable to enable the expansion member to be separated from the end cap as the expansion member is being moved inwardly relative to the core as aforesaid.